

Work Order ID 67396-2

SPLIT



Page 1

Friday, March 18, 2011 6:39:28 AM

Item ID: D2230-1

Accept



Setup Start



Revision ID:

Item Name: Lug

Stop



Start Date: 3/18/2011 Start Qty: 100.00

23



Cust Item ID:

Required Date: 4/6/2011 Req'd Qty: 100.00



Customer:

Reference:

Approvals: Process Plan:

CX

Date: 11/03/18

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2230

Rev G

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut D2423 extrusion to 0.82"

Batch:

Cut extrusion @ ymetec

CX 11/03/18

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FA927

DWG REV

FOLIO REV

(Check for crack while loading into the machine)

2- deburr rough edges

issue P/O to ymetec

P/O: 13677

Machine 20 per REV. G

CX 11/03/18

100

Work Order ID 67396

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Page 2

Item ID: D2230-1

Accept

Revision ID:

Item Name: Lug

Start Date: 3/18/2011 Start Qty: 100.00

Required Date: 4/6/2011 Req'd Qty: 100.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2 - Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

used + inspect for transfer damage + attached cap to w/o

4/13/31 (23)

130

QC3 - Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

Sub 3/31

count
(x23)

140

Chemical Conversion Coat per QSI005 4 1

0.00

Hand Finish

Memo

0.00

Hand Finishing

23 BR 11-3-31

Work Order ID 67396

Friday, March 18, 2011 6:39:28 AM



Page 3

Item ID: D2230-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 3/18/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 4/6/2011 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

23 ϕ JH 11/03/11

160

White Gloss (Ref 4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME

OVEN TEMPERATURE

FINISH TIME

9:05
320°
9:35

23 BR 11-4-11

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

23 ϕ JH 11/04/11

Work Order ID 67396

Friday, March 18, 2011 6:39:28 AM

Page 4

Item ID: D2230-1

Accept

Revision ID:

Item Name: Lug

Start Date: 3/18/2011 Start Qty: 100.00

Required Date: 4/6/2011 Req'd Qty: 100.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Rnn Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

180



Packaging

Packaging

Identify as per dwg & Stock Location

GA
w/o 67584

0.00

Memo

0.00

EP 04/12 (23)

190



QC

Quality Control

QC21 - Final Inspection - Work Order Release

0.00

Memo

0.00

11/4/12

11.04.12

Picklist Print

Friday, March 18, 2011 6:39:24 AM

Page 1

Work Order ID: 67396

Parent Item: D2230-1

Parent Item Name: Lug



Start Date: 3/18/2011

Required Date: 4/6/2011

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP D 00.11.01 Added inspection level 8, and removed P/O for powder coat EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423		Manufactured	No			110	f	477.0414	6.0683	7.189474			



Lug Extrusion



C211103118

Location

MAT006

43722

45800

63005

Loc Qty

477.0414265

180

16.1914265

280.85

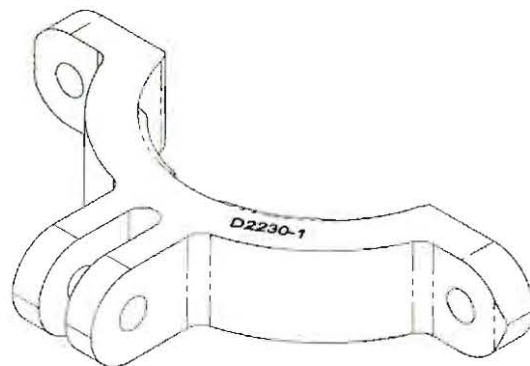
Loc Code

D2230-1P

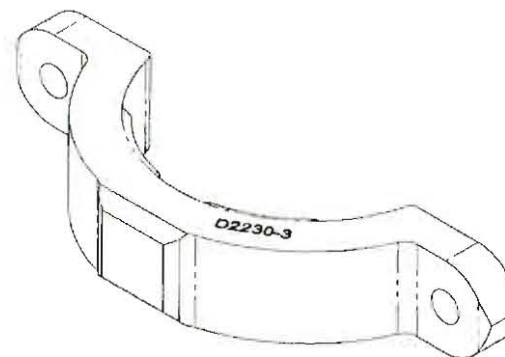
X100

1413/38 (23)

7.19



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

091103118
W10.67396

RELEASED
09/16/85



NOTES

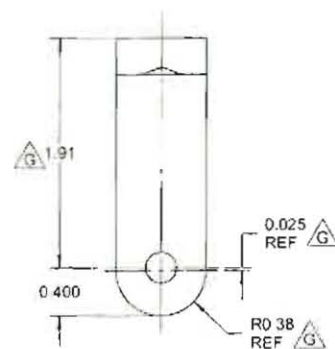
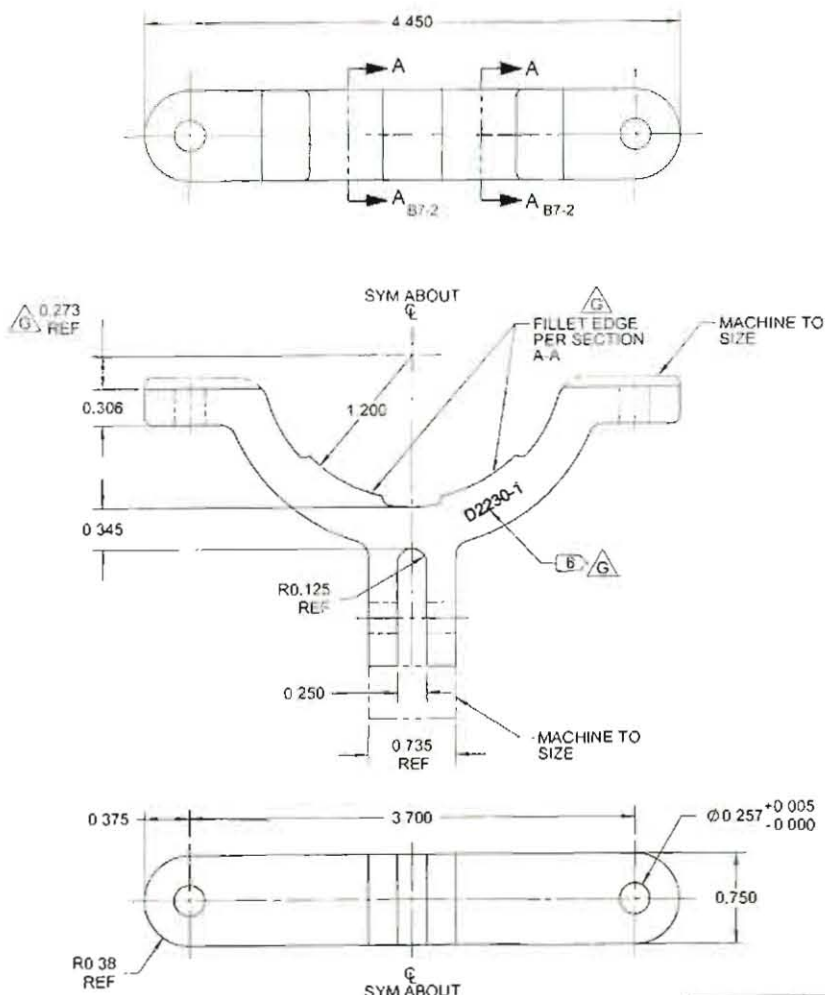
- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART OSI 005 4 1
POWDER COAT WHITE (4 3 5 1) PER DART OSI 005 4 3
- 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005
- 7) WEIGHT: -1 0.16 lbs
-3 0.14 lbs

G REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.		AJS	09.01.10
F	REDESIGN: R1.200 WAS 1.100	CP	95.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR		D2230	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR		MOUNTING LUG	NTS
DATE	09.01.16	<small>COPYRIGHT © 1988 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY OTHER PURPOSE WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	

SECTION A-A D4.2
SCALE 2X



R0.06 MIN - R0.10 MAX
2 PL



D2230-1 MOUNTING LUG

W10.67396

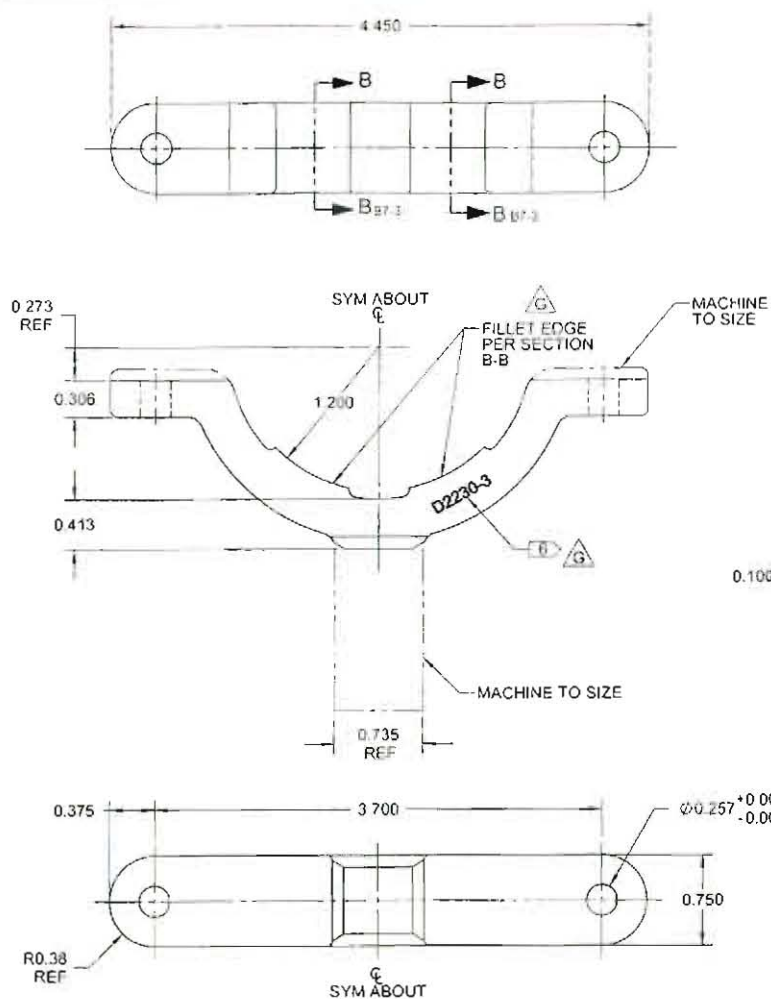
RELEASED
09/05/16

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO	REV. G
MFG. APPR.		D2230	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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SECTION B-B
SCALE 2X



R0.06 MIN - R0.10 MAX
2 PL



D2230-3 MOUNTING LUG

W10.67396

RELEASED
09/01/16

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV G
MFG APPR		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR		MOUNTING LUG	N/S
DATE	09.01.16	<small> COPYRIGHT © 1994 BY DART AEROSPACE LTD. THIS DOCUMENT IS UNCLASSIFIED AND IS BEING RELEASED TO THE PUBLIC DOMAIN. IT IS TO BE USED FOR ANY PURPOSE OR FOR ANY OTHER PERSON OR ENTITY. www.dart-aerospace.com </small>	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO13677

Purchase Order Date 3/18/2011

PO Print Date 3/18/2011

Page Number 1 of 1

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, QC K0B 1R0
CA

Contact Name

Vendor Phone

613 678 3957

Vendor Fax

613 678 3956

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

CL 11/03/18

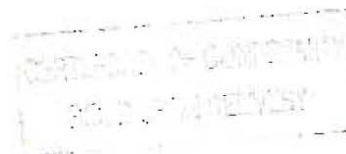
Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2230-1P	LUG	3/31/2011 Yes	100.00 Each	Dart Truck	\$19.9500	\$1,995.00

MC 23 11/03/31

Special Inst: MACHINE AS PER DWG D2230 REV G
B67396

PO Total:

\$1,995.00



Change Nbr:

1

Change Date: 3/18/2011

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0
Tel: (613) 678-3957
Fax (613) 678-3956

Delivery Slip No.: 17854
Date Mar 30, 2011
Page 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 13677	Sold By: Walz, Christian D.
Shipped By: your truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-1 Mounting Lug Material supplied by DART. D2423 B63005	Each	100	23	77
Received by _____		Thank you for your order!		



CERTIFICATE OF CONFORMITY

SOLD TO

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO

same

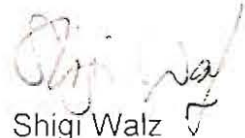
<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
23	D2230-1	Mounting Lug	13677

MATERIAL: supplied by DART D2423 B63005

Sub 131

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, March 30, 2011